

Grey

Dart Aerospace Ltd.

Date: Monday, 27/04/2009 11:42:20 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001	Drawing Name : BRACKET
Job Number : 47491	
Estimate Number : 11140	
P.O. Number :	Part Number : D32053
This Issue : 27/04/2009 S.O. No. :	Drawing Number : D3205 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 35209	Material :
Written By :	Due Date : 10/05/2009 Qty: 20 Um: Each
Checked & Approved By : <u>JUD 09.04.27</u>	
Comment : Est B 05.01.31 Revised Step 10 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X02000	6061-T6 Bar .250 X 2.00
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Comment: Qty.: 0.2284 f(s)/Unit Total : 1.3703 f(s)
6061-T6 Bar .25" X 2.0"
Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)(M6061T6B0.250x02.000)
Identify for D3205-3
Batch: M15949

JL 09/04/28

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks: 2.00" x 0.250" x 2.480" long Bar (+0.030/-0.000)

JL 09/04/28

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine D3205-3 as per Folio FA343 and Dwg D3205
Identify as D3205-3
Deburr and Tumble

09/04/29 (20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/04/29 (20)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

88 09/04/29 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



20

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BP 09-04-30

7.0

POWDER COATING

POWDER COATING



m109091

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

X20

START TIME:

13:25

OVEN TEMPERATURE:

320°

FINISH TIME:

13:55

UMD/FZ

09/04/30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JH

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-01

X20

9.0

PACKAGING 1

PACKAGING RESOURCE #1



20x

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

197

9/5/11

36

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-01

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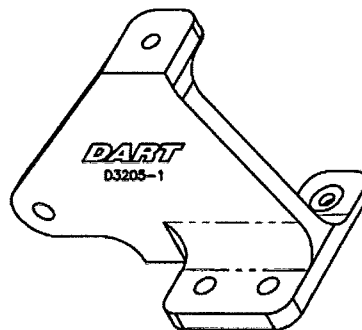
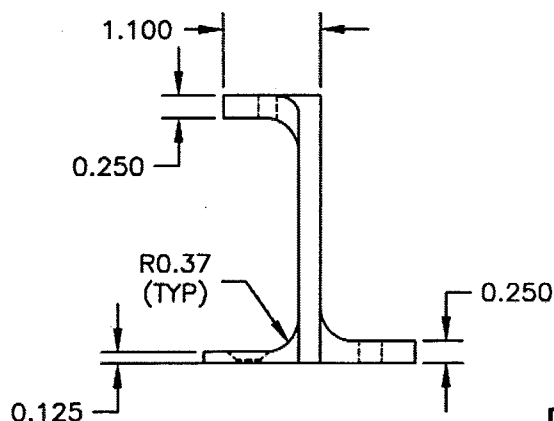
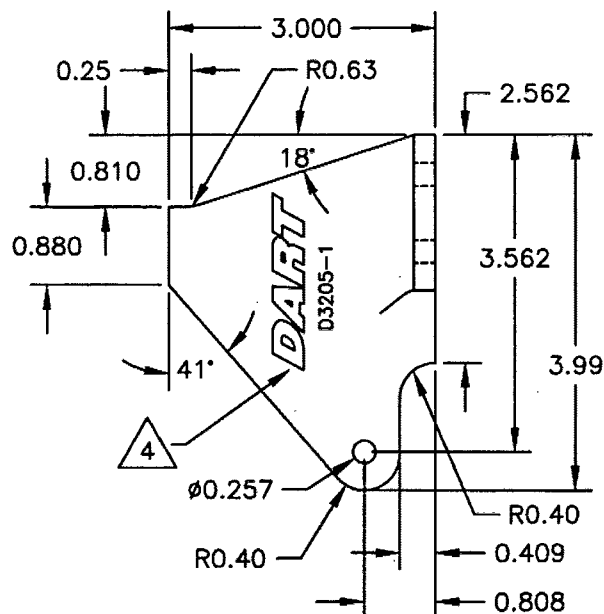
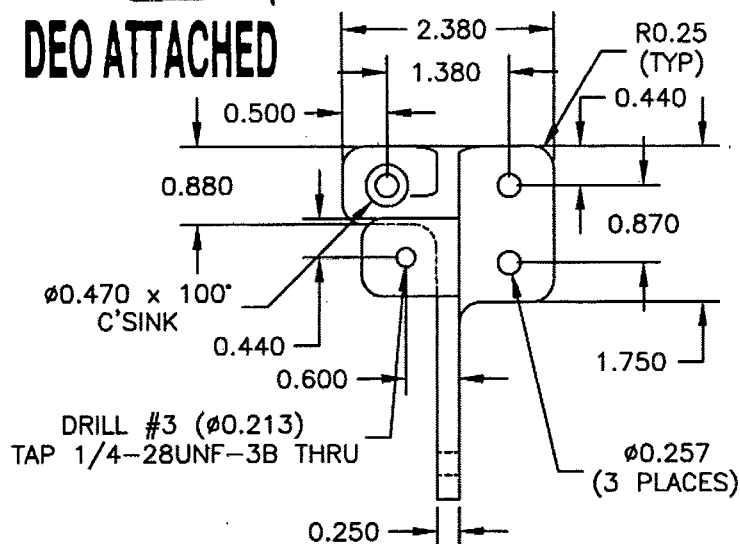
NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3205	REV. A SHEET 1 OF 2
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05

DEO ATTACHED



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
QSI 005 4.3/1791

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

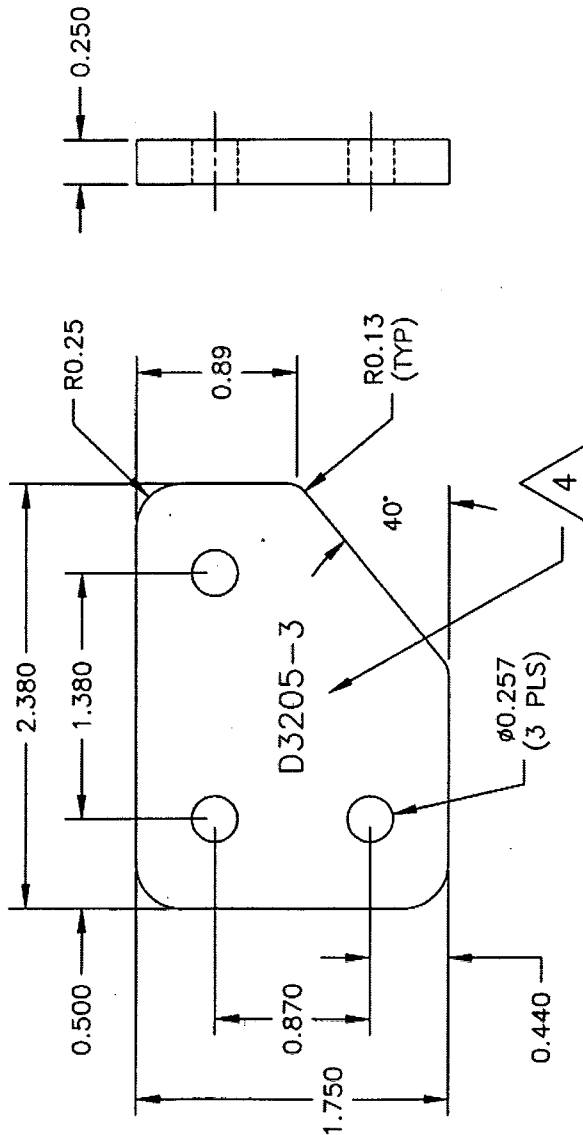
NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3205	REV. A SHEET 2 OF 2
DATE 04.01.27	TITLE BRACKET		SCALE 1:1

RELEASED
04.04.05 #

DEO ATTACHED



D3205-3 BACK PLATE

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANITEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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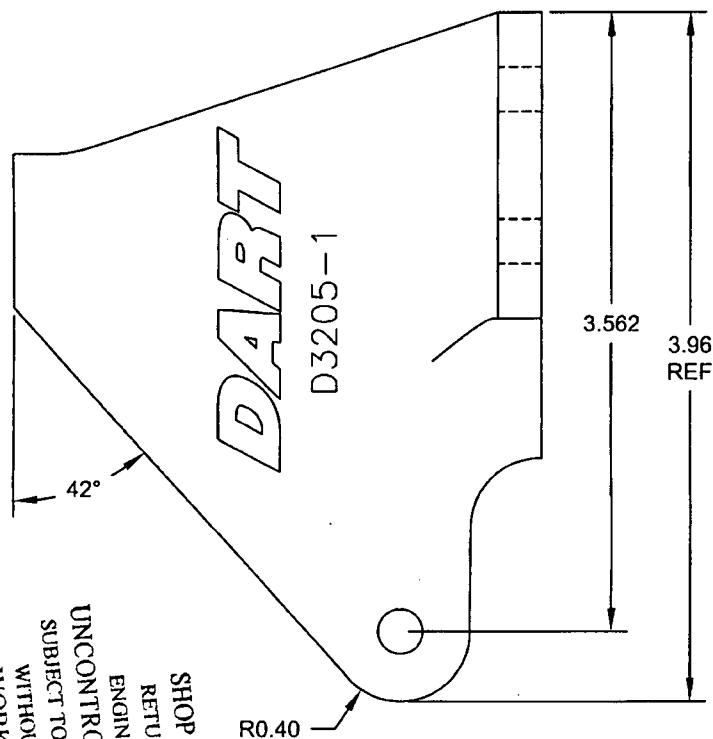
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NOTE: Date & initial all entries

DRAWING NO. D3205	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3205-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 08.12.01	DATE 08.12.01	DATE 08/12/01	DATE 08/12/01	DATE 08.12.01		

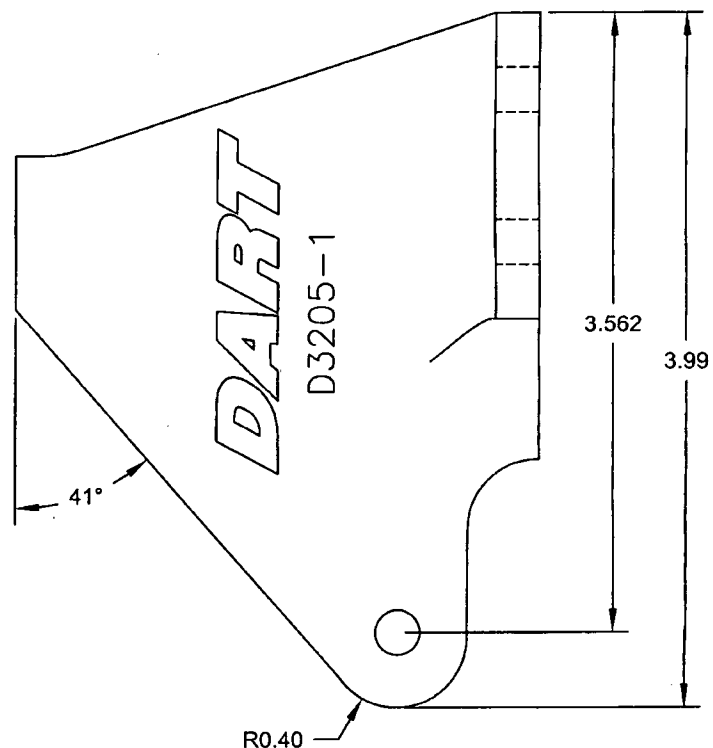
SHEET 1 MODIFY D3205-1 AS SHOWN:

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NO. 1141

WAS:



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